

Work Order ID 101990

101990

Page 1

May-22-13 10:56:42 AM

Item ID: D4770-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

Start Date: 5/22/13 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4770	A								
100		0.00							
100									
Cold Saw	Memo	0.00							
Hyd Mech	Cut blanks as per dwg								
110		0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Mill as per folio FB182 & dwg D4770-1, FOLIO REV: _____ DWG REV: _____								

2-Deburr as required

EXTRA MATERIAL WILL BE CUT AT ASSEMBLY

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Start Qty: 8.00

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Cust Item ID:

Required Date: 5/24/13

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: W/1001

0.00

140

Packaging

Memo

0.00

Packaging

W/P 13/05/24
D.S.

13-5-24

DAS
04
8-83

8 *EL* *13-5-28*

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N900040100

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Item Name: Bar

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Required Date: 5/24/13

Req'd Qty: 8.00

8

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

13/5/29

ME

13-5-29

Picklist Print

May-22-13 10:56:41 AM

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Work Order ID: 101990

Parent Item: D4770-1

Parent Item Name: Bar

Start Date: 5/22/13

Required Date: 5/24/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.04.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 304 BAR .250 x .500		Purchased	No			100	f	482.3470	1.666	14.029474			

Location

Loc Qty

Loc Code

MAT049

482.347

123902

31.492

124518

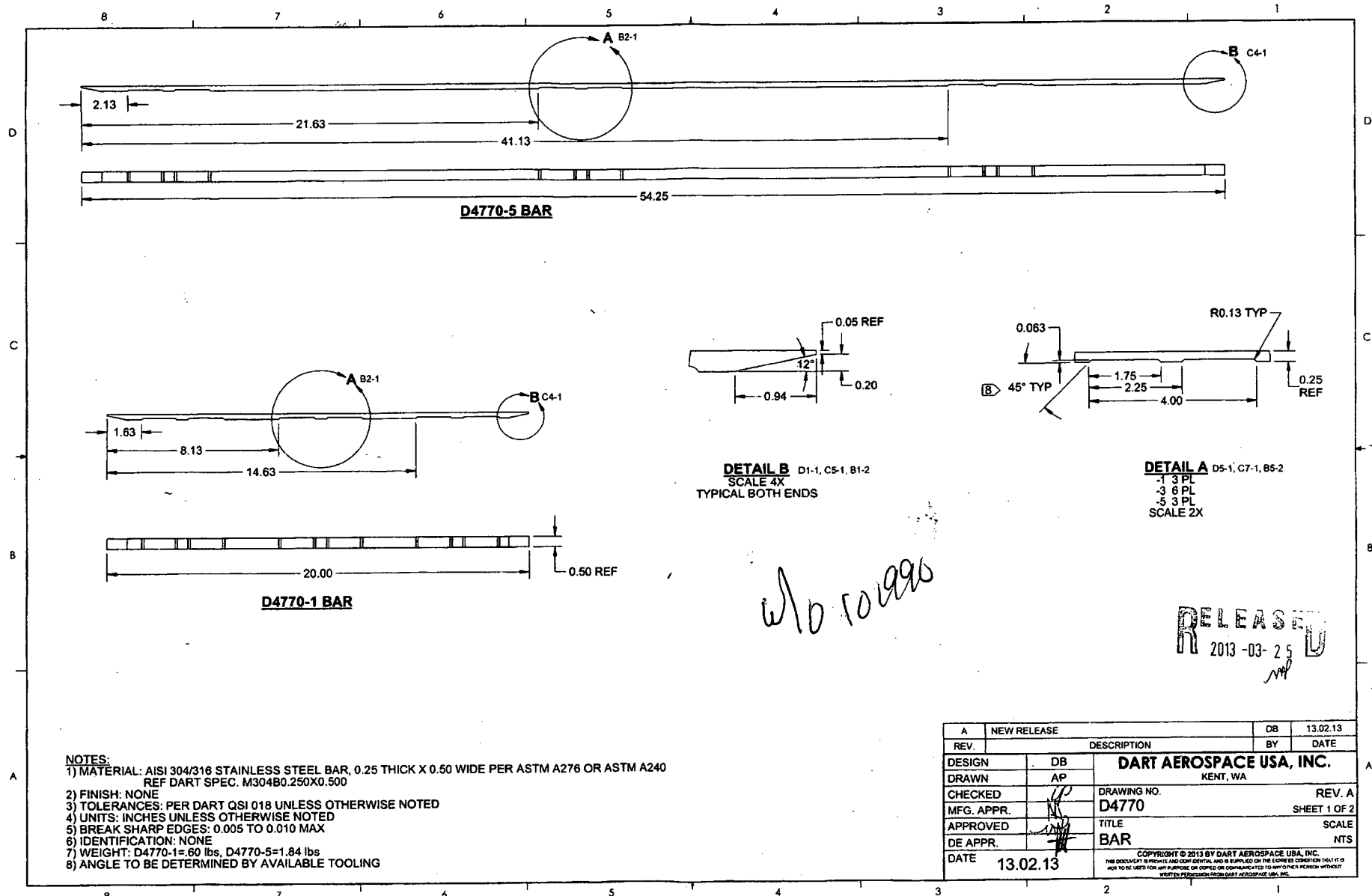
222.855

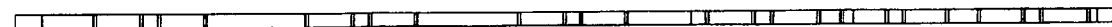
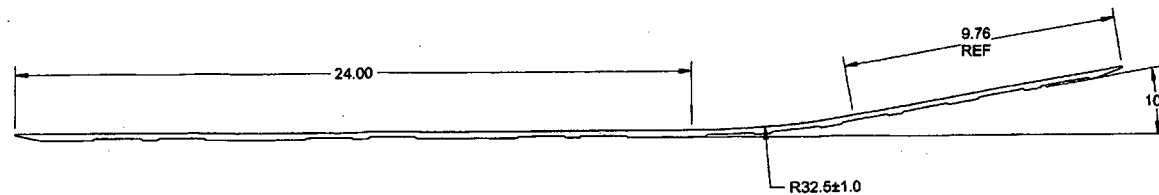
125367

228

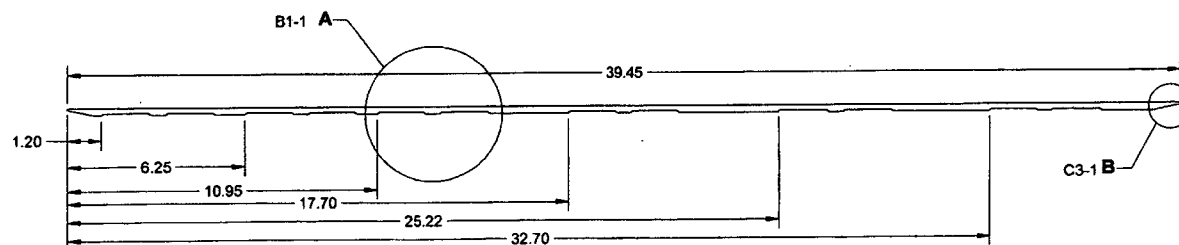
13,333'

WIP 13/05/24





D4770-3 BAR
(MAKE FROM D4770-3F)



D4770-3F BAR
(FLAT PATTERN)

RELEASED
2013-03-25

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4770-3=1.22 lbs,

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4770	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
DATE	13.02.13	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

